

Stop - June 14th

Dart Aerospace Ltd.

24

Date: Tuesday, 5/29/2007 9:58:25 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SKID INSTALLATION RH,THRU BOLT
Job Number : 32708	
Estimate Number : 12890	
P.O. Number : <i>N/A</i>	Part Number : D206642614
This Issue : 5/29/2007 S.O. No. : <i>N/A</i>	Drawing Number : IIN D206-642 REV K
Prsht Rev. : <i>NC</i>	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : K
Previous Run : <i>N/A</i>	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 6/15/2007 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.05.29	
Comment : Est Rev: B Revised Pick List 05-10-27 KJ/EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD206-642-614 CHG002

KS 07-05-30

2.0	32708A	FLOAT SKIDTUBE HIGH GEAR 206 A/B
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Comment: Sub-Component FLOAT SKIDTUBE HIGH GEAR 206 A/B

D206-642-613 SUB-COMPONENT

B 31964A

07/06/17

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D206651041	206 A/B GHW Kit
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

206 A/B GHW Kit

Batch: *627963*

✓

5.0	D26652	Saddle, RH, Fwd,Aft, Out
-----	--------	--------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Saddle, RH, Fwd,Aft, Out

Batch: *628602*

✓

07/05/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D26662

Saddle, RH, Fwd, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Saddle, RH, Fwd, Aft, In

Batch: B28551 ✓ ✓

7.0

D26672

Saddle, RH, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Saddle, RH, Aft, Out

Batch: B9066 ✓ ✓

8.0

D26682

Saddle, RH, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Saddle, RH, Aft, In

Batch: B16273 ✓ ✓

9.0

AN3C41A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) ✓

Batch: M19349 ✓

10.0

D2652

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bushing

Batch: B30816 ✓ ✓

11.0

MS210433

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Batch: M103286 ✓ ✓ ✓

12.0

NAS1515H5

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Batch: M101925 ✓ ✓ ✓

EP 507/65/290

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Drawing Name: SKID INSTALLATION RH, THRU BOLT

Job Number: 32708

Part Number: D206642614

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN5C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M19185 ✓ ✓

14.0

AN5C11A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Batch: M19185 ✓ ✓

15.0

AN5C32A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Batch: M18918 ✓ ✓

16.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M101418 ✓ ✓

17.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: M19349 ✓ ✓

18.0

NAS1515H5L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: M101925 ✓ ✓

19.0

AN4C6A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Batch: M103344 ✓ ✓

Handwritten signature and date: 05/29/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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Seq. #:

Machine Or Operation:

Description :

20.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

WASHER

Batch: M103691 ✓ ✓

21.0

NAS1515H4L

Inventory



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Inventory

Batch: M101542 ✓ ✓

22.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Nut

Batch: M104537 ✓ ✓

23.0

AN6C44A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

Batch: M103964 ✓ ✓

24.0

MS210436

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

NUT

Batch: M103693 ✓ ✓

25.0

AN960C616

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: M19185 ✓ ✓

26.0

D2712

Set Screw



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Set Screw

Batch: B31927 ✓ ✓

EP 5/29/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Part Number: D206642614

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D2884

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Saddle Spacer

Batch: B29453 ✓

28.0

D2885

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Saddle Spacer

Batch: B29199 ✓

29.0

AN3C36A



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Batch: M19349 ✓

30.0

AN960C10L

washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

washer

Batch: M101692 ✓

31.0

NAS1515H3L

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Batch: M19565 ✓

32.0

MS210433

Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

Nut

Batch: M103286 ✓

33.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inventory

Batch: B26772 ✓

CP 507/05/290

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 32708

Part Number: D206642614

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN5C35A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Batch: 1718918 * ✓

35.0

AN5C13A



Comment: Qty.: 1.0000 Each(s)/Unit Total : ✓ 1.0000 Each(s)

Batch: 1718918 - ✓

CP 507/05/29 @

36.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

CP 507/05/30 (1)

CP 507/05/30 (1)

37.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-614

Location: A

PPP Rev: A

CP 507/05/17

CP 507/05/17

38.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



CP 507-06-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.7 206A/B High Gear Float Skidtubes (TRI-BAG COMPATIBLE)

Item	Qty -611	Qty -612	Qty -613	Qty -614	Qty -641	Qty -645	Part Number	Description
	X						D206-642-611	SKIDTUBE INSTALLATION, LH
		X					D206-642-612	SKIDTUBE INSTALLATION, RH
			X				D206-642-613	SKIDTUBE INSTALLATION, LH, THRU BOLT
				X			D206-642-614	SKIDTUBE INSTALLATION, RH, THRU BOLT
	1	1	1	1	X		D206-642-641	SKIDTUBE
						X	D206-642-645	WEARSHOE KIT (REPLACES -643 KIT)
	1	1	1	1			D206-651-041	* 206 GHW ADAPTER ⁽³⁾
1					1		D3288-041	SKIDTUBE ASSEMBLY
3					1		D2646	* AFT CAP ⁽¹⁾
4					2		AN3C4A	* BOLT ⁽¹⁾
5A					2		AN960C10L	* WASHER ⁽¹⁾
5B					2		NAS1515H3L	* WASHER ⁽¹⁾
6	1		1				D2665-1	SADDLE, FWD OUT, LH
6		1		1			D2665-2	SADDLE, FWD OUT, RH
7	1		1				D2666-1	SADDLE, FWD IN, LH
7		1		1			D2666-2	SADDLE, FWD IN, RH
8	1						D2665-1	SADDLE, AFT OUT, LH
8		1					D2665-2	SADDLE, AFT OUT, RH
8			1				D2667-1	SADDLE, AFT OUT, LH
8				1			D2667-2	SADDLE, AFT OUT RH
9	1						D2666-1	SADDLE, AFT IN, LH
9		1					D2666-2	SADDLE, AFT IN, RH
9			1				D2668-1	SADDLE, AFT IN, LH
9				1			D2668-2	SADDLE, AFT IN, RH
10	8	8	8	8			AN3C41A	BOLT
11	16	16	16	16			D2652	BUSHING
12A	8	8	8	8			MS21043-3	NUT
12B	16	16	16	16			NAS1515H5	WASHER
13	4	4	4	4			AN5C7A	BOLT
14	4	4	4	4			AN5C11A	BOLT
14A	4	4	4	4			AN5C32A	* BOLT ⁽²⁾
14B	4	4	4	4			MS21043-5	* NUT ⁽²⁾
15A	8	8	8	8			AN960C516L	WASHER
15B	8	8	8	8			NAS1515H5L	WASHER
16	12	12	12	12			AN4C6A	BOLT
17A	24	24	24	24			AN960C416L	WASHER
17B	24	24	24	24			NAS1515H4L	WASHER
18	12	12	12	12			MS21043-4	NUT
20A					7	7	D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A					1	1	D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A					1	1	D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B					1	1	D3536-15	* GASKET ⁽¹⁾
23A					1	1	D3535-21	* WEARSHOE ⁽¹⁾ (REPLACES D2656-21)
23B					1	1	D3536-21	* GASKET ⁽¹⁾
24A					1	1	D3535-41	* WEARSHOE ⁽¹⁾ (REPLACES D3287-3)
24A					1	1	D3536-41	* GASKET ⁽¹⁾
25A					1	1	D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B					1	1	D3536-35	* GASKET ⁽¹⁾
26A					64	64	AN3C4A	* BOLT ⁽¹⁾
26B					64	64	AN960C10L	* WASHER ⁽¹⁾
26C					64		ALS7-1032-130	* INSERT ⁽¹⁾
								(or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
28	2	2	2	2			AN6C44A	BOLT
29A	2	2	2	2			MS21043-6	NUT
29B	4	4	4	4			AN960C616	WASHER

continued on next page...

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Revision: K

Date: 06.09.25

continued from previous page...

Item	Qty -611	Qty -612	Qty -613	Qty -614	Qty -641	Qty -645	Part Number	Description
34					1		AN4C5A	BOLT
35					1		AN960C416	WASHER
36					1		D3413-1	RING
37	10	10	5	5			D2712	SET SCREW
38	2	2	2	2			D2884	SADDLE SPACER
39	2	2	2	2			D2885	SADDLE SPACER
50	9	9	9	9			AN3C36A	BOLT
52	18	18	18	18			AN960C10L	WASHER
53	18	18	18	18			NAS1515H3L	WASHER
54	9	9	9	9			MS21043-3	NUT
55	2	2	2	2			D3396-3	SPACER
56A	1	1	1	1			AN5C35A	BOLT
56B	1	1	1	1			AN5C13A	BOLT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3288-041 ASSEMBLY ABOVE
 (2) MAY BE REQUIRED ON -613/-614 INSTALLATIONS OR DART CROSSTUBES
 (3) NOT INSTALLED AS PART OF SKIDTUBE. USED TO MODIFY OEM GROUND HANDLING WHEELS

5.0 WEIGHT AND BALANCE:

5.1 D206-642-111/-112/-211/-212/-311/-312/-411/-412 Skidtubes and Saddles

The following weight and balance information is for Dart D206-642-111/-112/-211/-212/-311/-312/-411/-412 skidtube and saddle installations only. The weight and balance of the skidtube and saddle installations that are being removed from the aircraft are the responsibility of the installer.

Note that the long wearshoe and ground handling kits are optional installations for flight. Weights for these (*) items should be subtracted if they are removed or otherwise not installed.

5.1.1 206 A/B Low Gear Skidtubes

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
D206-642-111	17.4 lb	96.3 in	1676 in lb	-36.8 in	-640 in lb
206A/B LOW, LH	7.9 kg	2.44 m	19.3 m kg	-0.93 m	-7.3 m kg
D206-642-112	17.4 lb	96.3 in	1676 in lb	36.8 in	640 in lb
206A/B LOW, RH	7.9 kg	2.44 m	19.3 m kg	0.93 m	7.3 m kg
*D206-642-143	2.0 lb	96.3 in	193 in lb	+/- 36.8 in	+/- 74 in lb
WEARSHOE KIT	0.9 kg	2.44 m	2.2 m kg	+/- 0.93 m	+/- 0.8 m kg

5.1.2 206 A/B High Gear Skidtubes

Installation	Weight	LONGITUDINAL		LATERAL	
		Arm	Moment	Arm	Moment
206-642-211	18.6 lb	93.8 in	1745 in lb	-37.3 in	-694 in lb
206A/B HIGH, LH	8.4 kg	2.38 m	20.0 m kg	-0.95 m	-8.0 m kg
D206-642-212	18.6 lb	93.8 in	1745 in lb	37.3 in	694 in lb
206A/B HIGH, RH	8.4 kg	2.38 m	20.0 m kg	0.95 m	8.0 m kg
D206-642-213	18.6 lb	93.8 in	1745 in lb	-37.3 in	-694 in lb
206A/B HIGH, LH, THRU	8.4 kg	2.38 m	20.0 m kg	-0.95 m	-8.0 m kg
D206-642-214	18.6 lb	93.8 in	1745 in lb	37.3 in	694 in lb
206A/B HIGH, RH, THRU	8.4 kg	2.38 m	20.0 m kg	0.95 m	8.0 m kg
*D206-642-243	2.2 lb	93.8 in	206 in lb	+/- 37.3 in	+/- 82 in lb
WEARSHOE KIT	1.0 kg	2.38 m	2.4 m kg	+/- 0.95 m	+/- 1.0 m kg

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